

69.

5/29

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23689</b>
<b>Description: Lug</b>	<b>Part Number:</b>	<b>D2591</b>
<b>Drawing: D2591 Rev. D</b>	<b>Qty:</b>	<b>100 99</b>

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	HJ	05.06.27	100
2	METAL	Cut blanks: 2.700" long Material: ASTM A36 steel bar 2.50" X 0.75" thick Batch: <i>m175800</i>	SD	05.07.12	99
3	HAAS	Machine per Folio FA039 <i>m17664</i>	SD	05.07.12	99
4	QC	Inspect Level 2	SD	05.07.13	99
5	QC	Inspect Level 8	EC	05.07.13	99
6	METAL	Tumble	N/A		
7	METAL	Deburr after tumbling if necessary	SD	05.07.13	99
8	QC	Inspection Level 5	EC	05.07.13	99
9	STORES	Identify and Stock	HJ	05.07.13	99
10	EXPEDITING	Close W/O <i>5.69</i> Inspection Level 21 Cost/part: <i>5.69</i>	HJ	05.07.15	99
			EC	05.10.14	99

P70V

EC

Rev	Date	Change	Revised By	Approved
C	98.01.21	Changed Rev of Dwg	BW	
D	98.04.17	Re-format	KB	
E	99.07.06	Re-format, Added bevel	DM	
F	99.09.14	Remove bevel, added tumble	EC	
G	00.03.15	Now goes on Haas	EC	
H	01.11.29	Reformat	SM	EC

RELEASED

UNDER REVIEW

03.06.05 RF

combine with

D205-641-010

ADD 9161

EC 01.11.30

*Ref 04.12.01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-07-13	6	Remove permanently		05-07-14	N/A		05-07-14

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-07-12	3	part came out of use		destroy	05-07-12	05-07-14		05-07-14

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: Date: 05/07/14

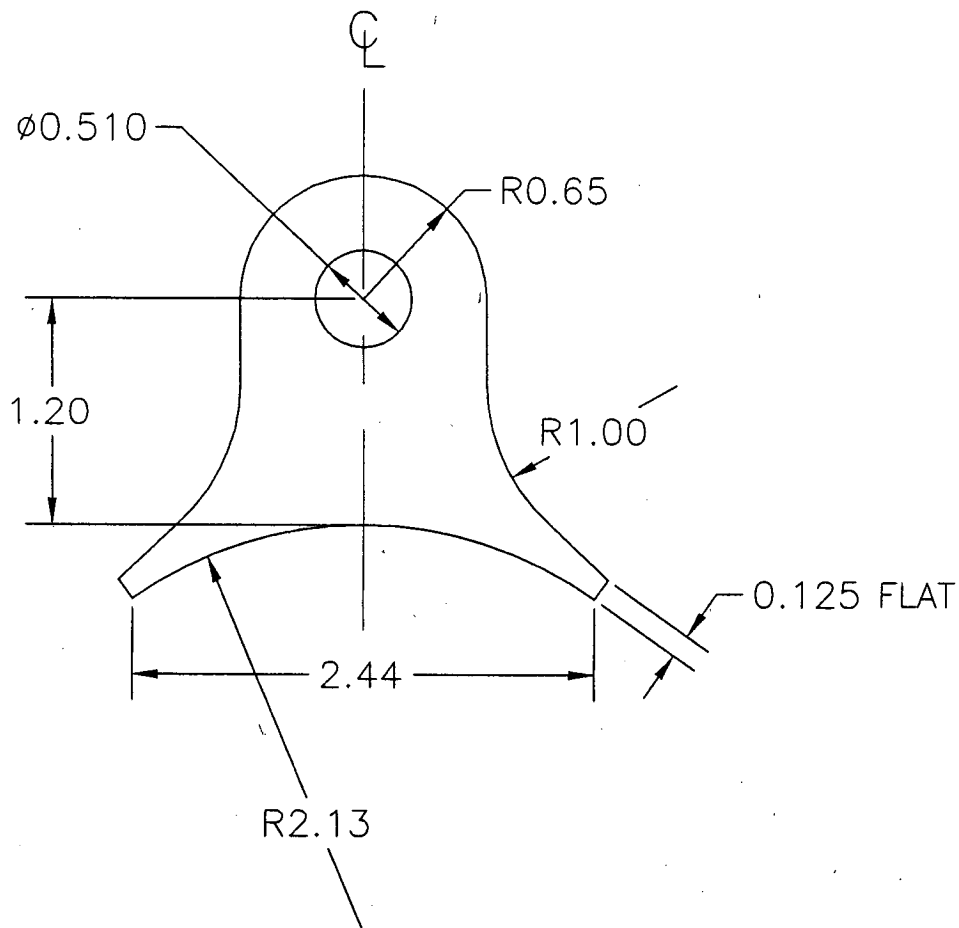
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN <i>MEY</i>	DRAWN BY <i>MEY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D259.1	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED  
98.01.21 DS



BREAK ALL SHARP CORNERS ~~0.010 TO 0.020~~

MATERIAL: ASTM A36 STEEL 0.50 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

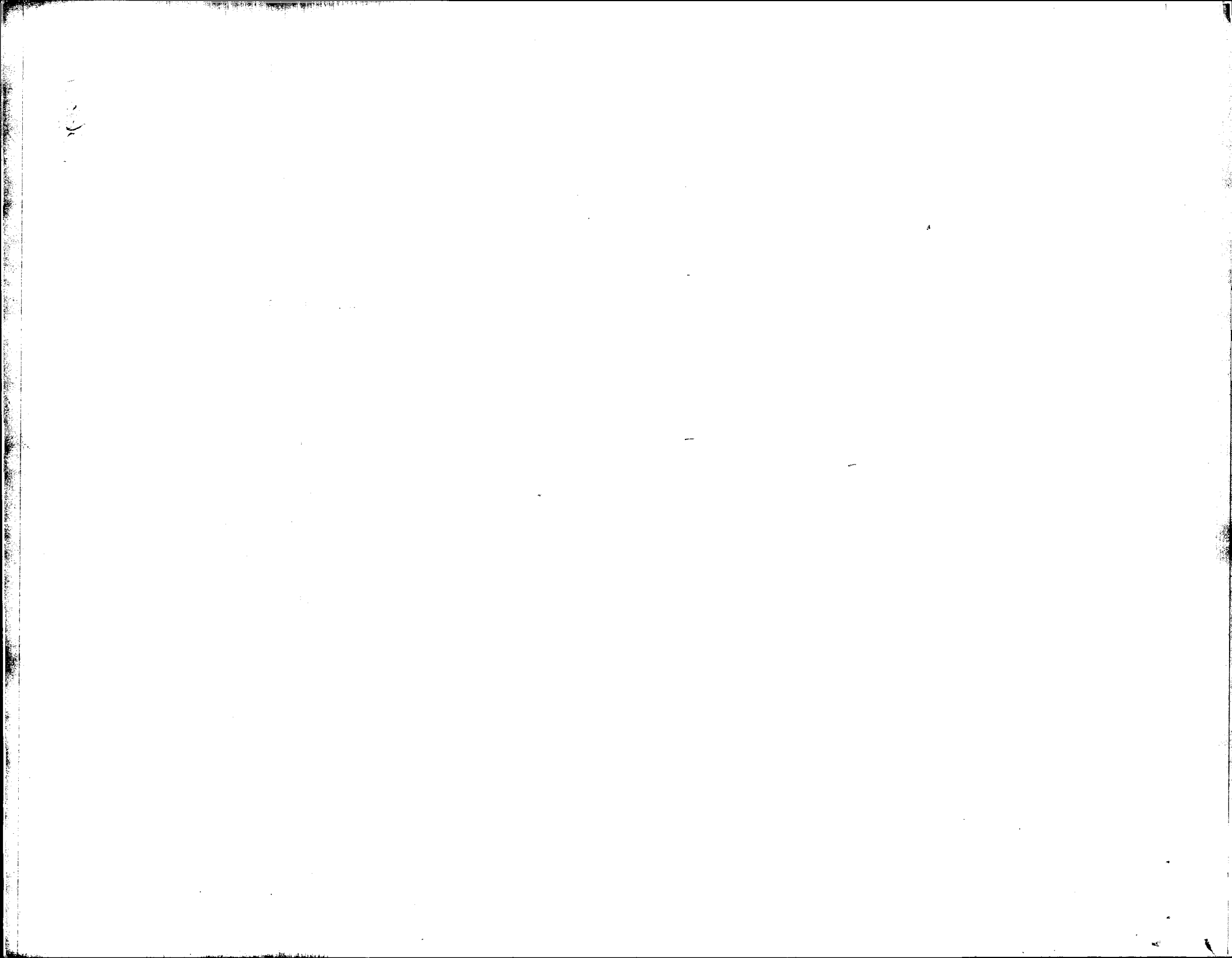
PART IS SYMMETRIC ABOUT CENTER-LINE

ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
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ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO 23689



# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 27, 2005  
08:10 am

Work Order No : 0023689  
Project Name : D2591  
Project For : WK529  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2591  
Description : Lug  
Manufactured : Yes  
Amount Req'd : 100  
Amount Done : 0  
Start Date : 06-27-05  
Est Finish Date : 07-25-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

